

Ship June 05

Work Order ID 67535

Monday, March 28, 2011 9:24:20 AM



Page 1

Item ID:	D2282-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle Assembly				Stop	
Start Date:	3/28/2011	Start Qty:	150.00			
Required Date:	4/4/2011	Req'd Qty:	150.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	11-03-28	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per D2282-043 Saddle Assembly A/RER316L SS Filling Rod Dwg Rev: <u>REV (E)</u>								
110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Grind weld with rough pad and brown pad, take all welding marks out and debur holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***								
120		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

148 11-06-21 JBL/EZ

16/ Ae 11.06.27

11.06.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

Work Order ID 67535


Monday, March 28, 2011 9:24:20 AM


Page 2


Item ID: D2282-043 Accept  Setup Start 
Revision ID: 
Item Name: Saddle Assembly Stop 
Start Date: 3/28/2011 Start Qty: 150.00  Cust Item ID:
Required Date: 4/4/2011 Req'd Qty: 150.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130		0.00							
									
Small Fab	Memo	0.00							
Small Fab	1 -Tumble								

150	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

160	Identify as per dwg & Stock Location: <u>G.A</u>	0.00							
									
Packaging	Memo	0.00							
Packaging									

131-6-28

448

E/S 4/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 67535

Monday, March 28, 2011 9:24:20 AM



Page 3

Item ID: D2282-043

Accept



Setup Start



Revision ID:

Item Name: Saddle Assembly

Stop



Start Date: 3/28/2011 Start Qty: 150.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 150.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28

MF

11-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 9:24:25 AM

Page 1

Work Order ID: 67535

Parent Item: D2282-043

Parent Item Name: Saddle Assembly

Start Date: 3/28/2011

Required Date: 4/4/2011

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2281

Manufactured No

100

Each

67.0000

1

150



Jack Saddle



11-06-28

67539 x 81

Location

Loc Qty

Loc Code

WA020

67

64508

67

67

D2282-7

Manufactured No

100

Each

141.0000

2

300



Tube



11-06-28

Location

Loc Qty

Loc Code

WA019

141

64507

141

(105)

67540

300

195

*

11-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

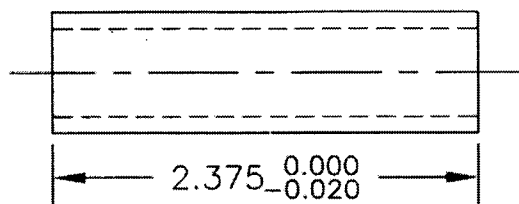
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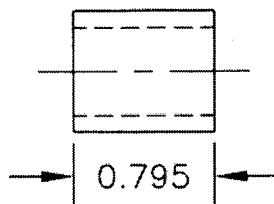


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

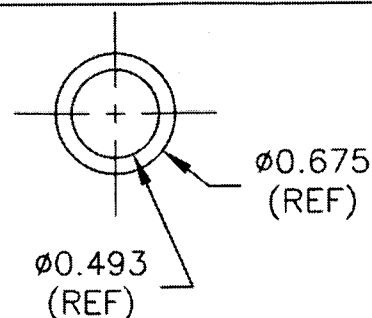
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05/09/16



D2282-3

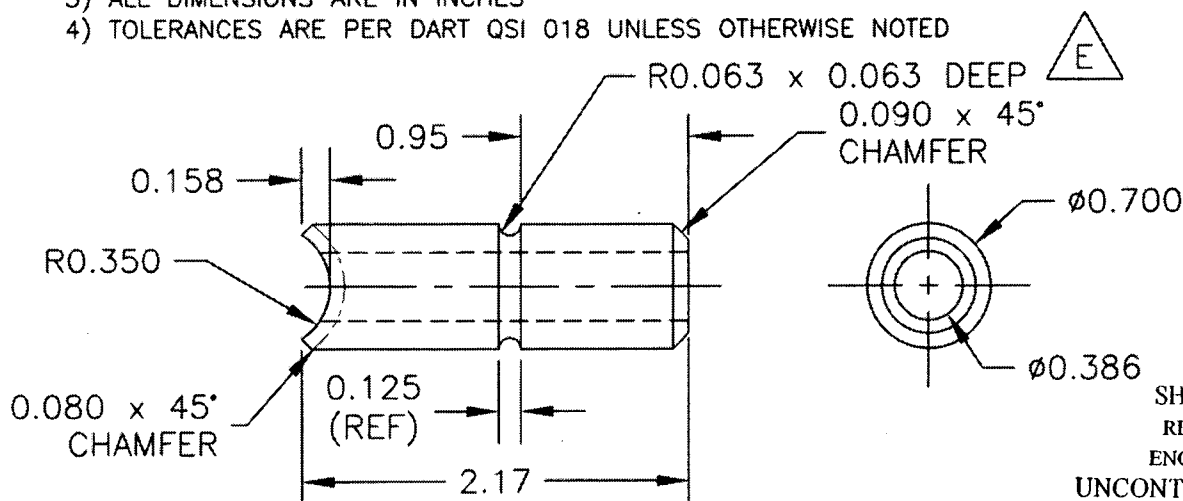


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

07885-
P/M-0821

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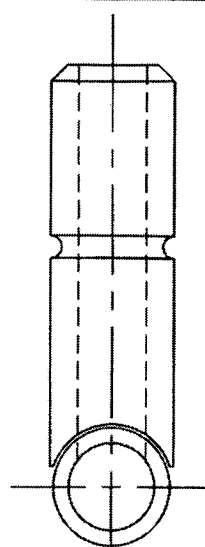
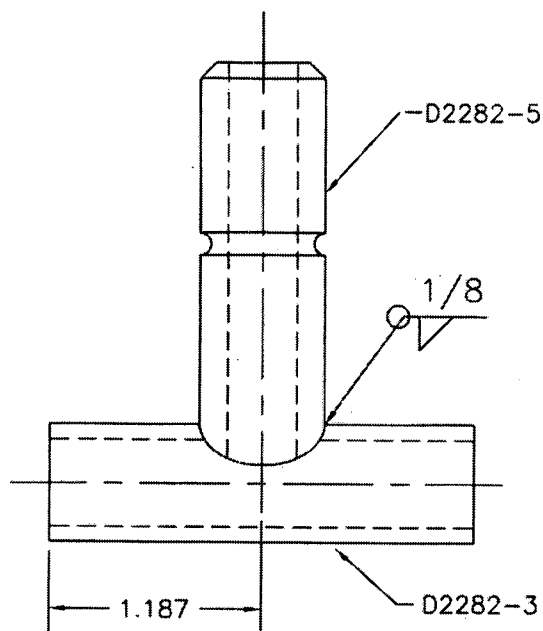
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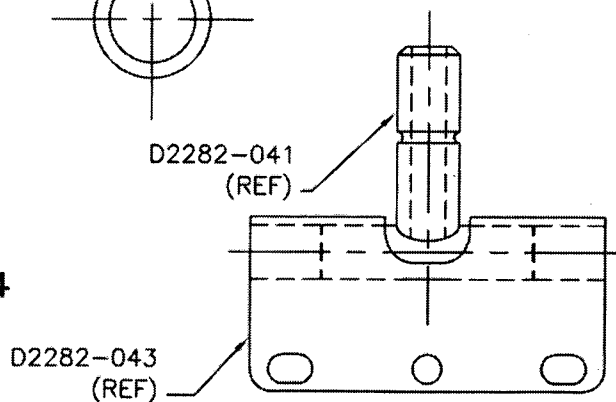


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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

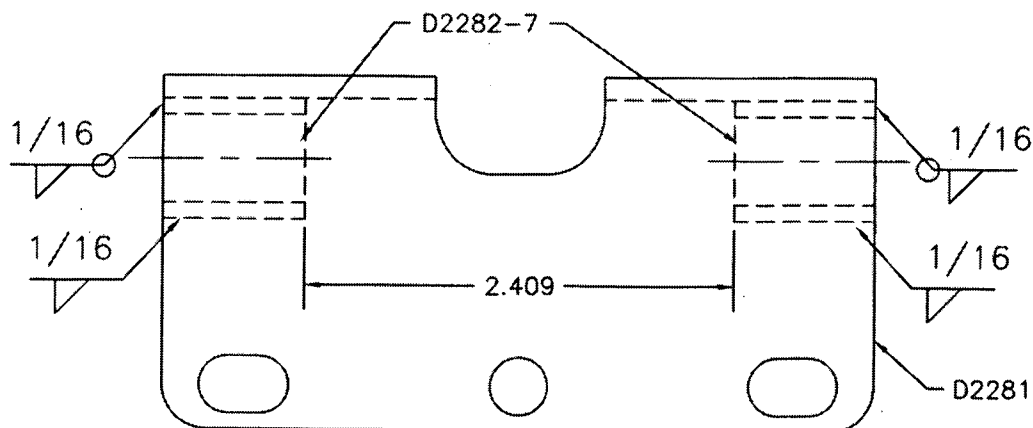


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[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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